

Give this one too

Dart Aerospace Ltd.

Date: Thursday, 7/20/2006 1:10:19 PM
 User: Linda Lacelle

D/A Stow

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SKID TUBE ASSEMBLY

Job Number : 27999A

Estimate Number : 10023

P.O. Number :

Part Number : D205634041

This Issue : 7/20/2006

S.O. No. :

Drawing Number : D2580 REV C

Prsht Rev. : NC

Project Number : N/A

First Issue : 7/20/2006

Type : LANDING GEAR

Drawing Revision : C

Previous Run : 27913A

Material :

Due Date : 8/20/2006

Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step
 30 KJ

Est Rev: O 06.02.28 Added paperwork EC

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description:

1.0

D25001190

Ext'n - I Beam Tube 4"

Comment: Qty.: 1.0400 Each(s)/Unit Total: 1.0400 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B24669

IT 06-08-15

2.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

3.0

D2596

205 Web

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B28025

IT 06-08-25

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburrr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

IT 06-08-17

per attached E-mail
 IT 06-11-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27999A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

pm 06-08-17①

6-Countersink holes as per Dwg D2580 without cutting fluid

pm 06-08-17①

7-Deburr and blow out all chips from inside of tube

pm 06-08-17①

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 MIX 855

Sikaflex expire date: 07-02-01

25 06-08-25

Start Time: 9:00

Fin Time: 7:00 am 06-08-26

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

> DP 6-8-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

DP 6-8-30

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3 Step _____

W/O:		WORK ORDER CHANGES							
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Job Number: 27999A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579 side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

spacers, weld one

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215Open holes to #6 Drill bit. Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640"and Debur

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

Inspect weld and Counterbore work to Step 20

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

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Job Number: 27999A

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0	D25771	Wearplate Fwd
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	

15.0	D25773	Wearplate Aft
------	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	

16.0	D25775	Wearplate, Centre
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	

17.0	ALS71032130	Insert
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Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	

18.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN960JD10L	Washer	

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Job Number: 27999A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	AN3-4A	Bolt	

20.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	D2594-3	O-RING	

21.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	D2594-1	Plug	

22.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: _____

23.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: _____

24.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: _____

W/O:		WORK ORDER CHANGES							
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 27999A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 _____

Sikaflex expire date: _____

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 _____

Sikaflex expire date: _____

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: _____

PPP Rev: _____

28.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06/11/07

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2799A

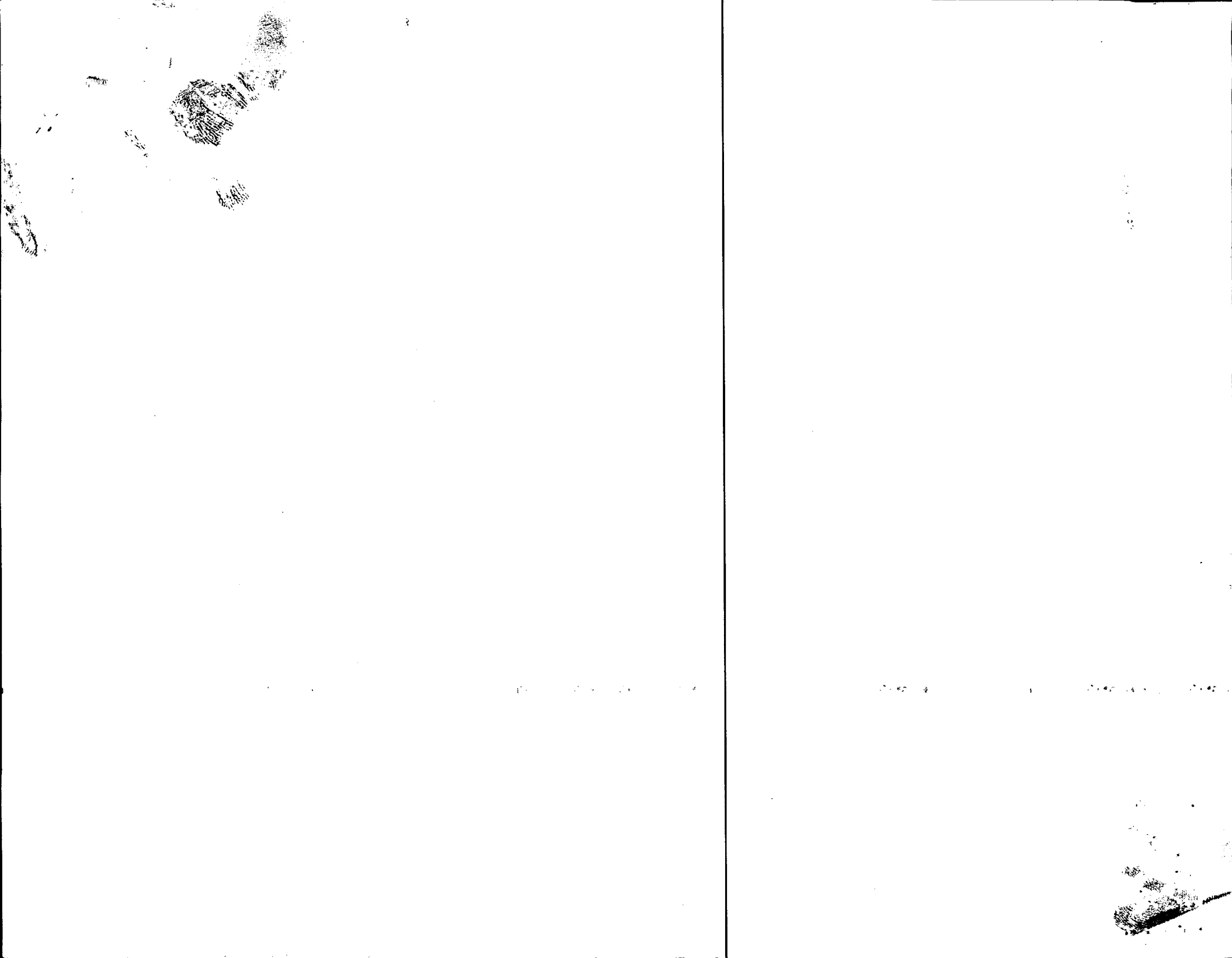


Diagram of the underside of a propeller showing grinding locations. Labels include: GRIND FLUSH (4 PLACES), GRIND FLUSH, GRIND FLUSH, LOCATION RIDGE ON UNDERSIDE OF D2576, and a reference to D2576.

Technical drawing of a bolt assembly. The drawing shows a circular cross-section of a component with a central hole. A bolt is shown passing through the hole. The following callouts are present:

- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)
- Ø.208
- AN3-4A BOLT (1)
- AN960J10L WASHER (1)
- (2 PLACES)
- D2575 CAP
- SEAL WITH SIKAFLEX-241

AFTER PERFORM

1. CHA
2. INSE
3. WEL

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C/BORE D2579 SPACER TO #0.437 X 1.00 DEEP

Diagram showing the elevation view of the bridge deck. Key dimensions and labels include:

- 37.50 (Total deck width)
- DISTANCE TO AFT END OF D2596 WEB
- 3 (Left side reinforcement)
- 7 (Right side reinforcement)
- 1.750 (Reinforcement spacing)
- 0.508 (TYP.) (40 PLACES) (Reinforcement spacing)
- REFER TO DETAIL A (Two locations)
- 8.750 (Dimension from left edge to first reinforcement circle)
- 17.375 (Dimension from left edge to centerline)
- 26.000 (Dimension from left edge to centerline)
- 34.188 (Dimension from left edge to centerline)
- 57.313 (REF) 7 EQUAL SPACES 8.188 PITCH (Dimension from centerline to right edge)
- 91.500 (Total length)
- 190.0 (D2500-1) (Total length)

Figure 1: Elevation view of the proposed road profile. The diagram shows a road cross-section with a centerline and a proposed profile line. Key dimensions include: a 1.4m offset from the centerline to the start of the profile; a 13.4m distance from the start of the profile to the first tangent point; a 1.0m distance between the two tangent points; a 32.0m distance from the second tangent point to the end of the profile; a 20.0m vertical offset from the centerline to the peak of the profile; and a 11m vertical offset from the centerline to the end of the profile. A 4% slope is indicated at the end of the profile.

[illegible]

RELEASE
98/09/17 DS

DESIGN <i>DAT</i>	DRAWN BY <i>CP</i>	DART DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA
CHECKED <i>DAT</i>	APPROVED <i>JS</i>	
DATE 98.08.26	DRAWING NO. D2580	REV. C SHEET 2 OF 2
	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24



NO. 1

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barelay Elliott
Joint Welding Procedure Tig
Part number and Job number A205 34041 / B280006 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into 205 Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/09/01 Qualifier David David

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 27999		
Estimate Number	: 10022		
P.O. Number	:	Part Number	: D205634011
This Issue	: 7/20/2006 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 7/20/2006 Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 27913	Material	:
Written By	: _____	Due Date	: 8/20/2006 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

Job Number:

Page 1

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NCR: Yes No DQA: _____ Date: _____

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Date: Thursday, 7/20/2006 1:09:46 PM
User: Linda Lacelle

Process Sheet

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Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 27999

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: _____

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



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QA: N/C Closed: _____ Date: _____

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 12:16 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: 205-634-041

My recommendation is as follows:

B28004 = acceptable as is
B28005 = cut to 11.0" height min
B28009 = acceptable as is
B28010 = acceptable as is
B27999 = scrap

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Thursday, November 02, 2006 4:21 AM
To: 'David Shepherd'
Subject: FW: 205-634-041

jmurdoch@dartaero.com
Q.C. COORDINATOR

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Wednesday, November 01, 2006 1:48 PM
To: 'davids@dartaero.com'
Cc: 'L Lacelle'
Subject: 205-634-041

Hi. Remember the 4 x D205 skids that the bend was too long in the front, and 1 was 1.5" over bent? Well we cut the tubes down to get the fwd dimension shorter, and closer to 32".

- B28004: L-33.25" H-11.0"
- B28005: L-33.5" H-11.5"
- B28009: L-30.5" H-11.5
- B28010: L-33.5" H-11.0
- B27999: L-33.5" H-10.75

We also did a dry fit of the fwd cap, and the cap will fit fine. Just on 1 tube, the back weld hole will have to be opened up max .250 longer. The guys have also put reference points on the cut saws to ensure that the bends are well with in tolerance before cutting. Does this look good to you, or will this cause a possible vibration? Do you recommend we cut off more? I think this will be ok.

jmurdoch@dartaero.com
Q.C. COORDINATOR

03/11/2006

